



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:

- A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE		1
1	MDC'C CAT. #110031	8" CF. NONROTATABLE FLANGE		1

ITEM	BY/DATE	DESCRIPTION	MATERIAL / SPEC	QTY
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PARTS LIST

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

LOG NUMBER V2930000-01

DESIGNER SHU/MUSCIA DATE 2/17/93

CHECKED BY D. SHU DATE 7/6/99

DESIGNER SHU/MUSCIA DATE 2/17/93

RESPONSIBLE ENGINEER D. SHU DATE 7/6/99

APPROVED/RELEASED

SEE PARTS LIST

SCALE HALF SIZE

SHEET 1 of 1

DRAWING NUMBER V2-930000-01

1	V2930000-01 WAS A14772			
	V2-930000-01 WAS			
	410509702-930000-00			
	(NEW LOG # & PART #)			
	8.000 [152.40] WAS 8.000 [101.60]	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			